

# Work Order ID 61174

August 11, 2010 7:42:13 AM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 8/11/10

Start Qty: 5.00



Cust Item ID:

Required Date: 8/20/10

Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 10/8/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2506

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506

☐ Dwg Rev:

F

☐ Prog Rev:

F

☐ 2-

Deburr if necessary

B10-8-16

(5)

304 . 040

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-8-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sidoo117

(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61174**

August 11, 2010 7:42:13 AM

Page 2

Item ID: D2506

Accept

Setup Start

Revision ID:

Stop

Item Name: Label Plate

Start Date: 8/11/10 Start Qty: 5.00

Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 5.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE  Memo 1-Form as per dwg D2506	0.00  0.00	88 07/08/25			⑤			
Brake NC									
140  QC	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	8.060605			⑤			
Quality Control									
150  Packaging	Identify as per dwg & Stock Location: _____  Memo Basket all	0.00  0.00							
Packaging									

10/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61174**

August 11, 2010 7:42:13 AM

Page 3

Item ID: D2506

Accept

Setup Start

Revision ID:

Stop

Item Name: Label Plate

Start Date: 8/11/10 Start Qty: 5.00

Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/26 *[Signature]**PS 10-8-26*  
*(5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 11, 2010 7:42:12 AM

Page 1

Work Order ID: 61174



Parent Item: D2506



Parent Item Name: Label Plate

Start Date: 8/11/10

Required Date: 8/20/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08 Now laser cut EC  
IPP C 06.12.13 ecn 822 ec  
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

19.5987

1.22

6.421053



304/316 .040 Sheet

1816-8-14

Location

Loc Qty

Loc Code

MAT

16.1522

114574

16.1522

MAT20

3.4465

112885

2.7475

113062

0.699

115440

115440

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	61174
<b>Description:</b> Label Plate		<b>Part Number:</b>	D2506
<b>Inspection Dwg:</b> D2506	<b>Rev:</b> F	<b>Page 1 of 1</b>	

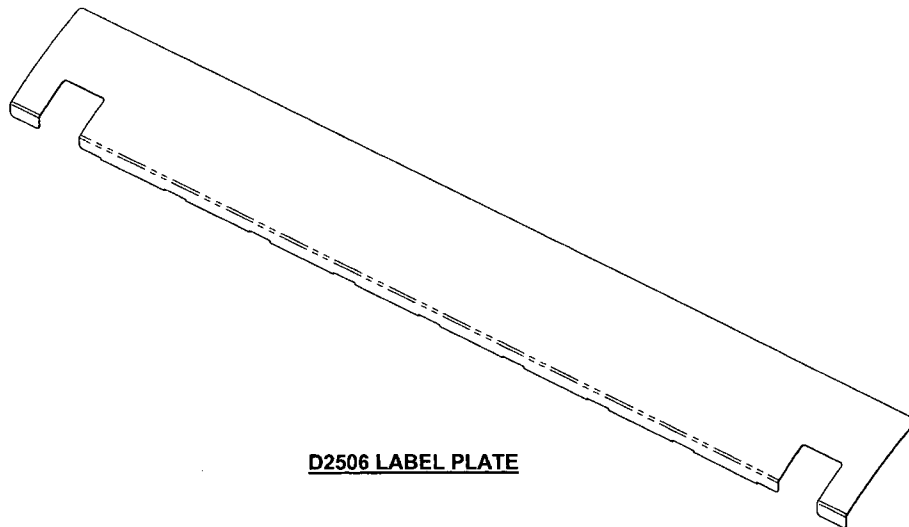
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.50	+/-0.030	4.505	X		V B02	
1.31	+/-0.030	1.315	X		V	
1.88	+/-0.030	1.877	X		V	
32.63	+/-0.030	32.63	X		T B01	
39.00	+/-0.030	39.00	X		T	
2.00	+/-0.030	1.995	X		V	
0.063	+/-0.010	.061	X		V	
1.00	+/-0.030	1.001	X		V	
2.95	+/-0.030	2.958	X		V	
0.040	+/-0.010	.034	X		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-8-16	<b>Date:</b> 10/08/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	
D	09.06.26	Dimensions update per Dwg Rev F	KJ	



**D2506 LABEL PLATE**

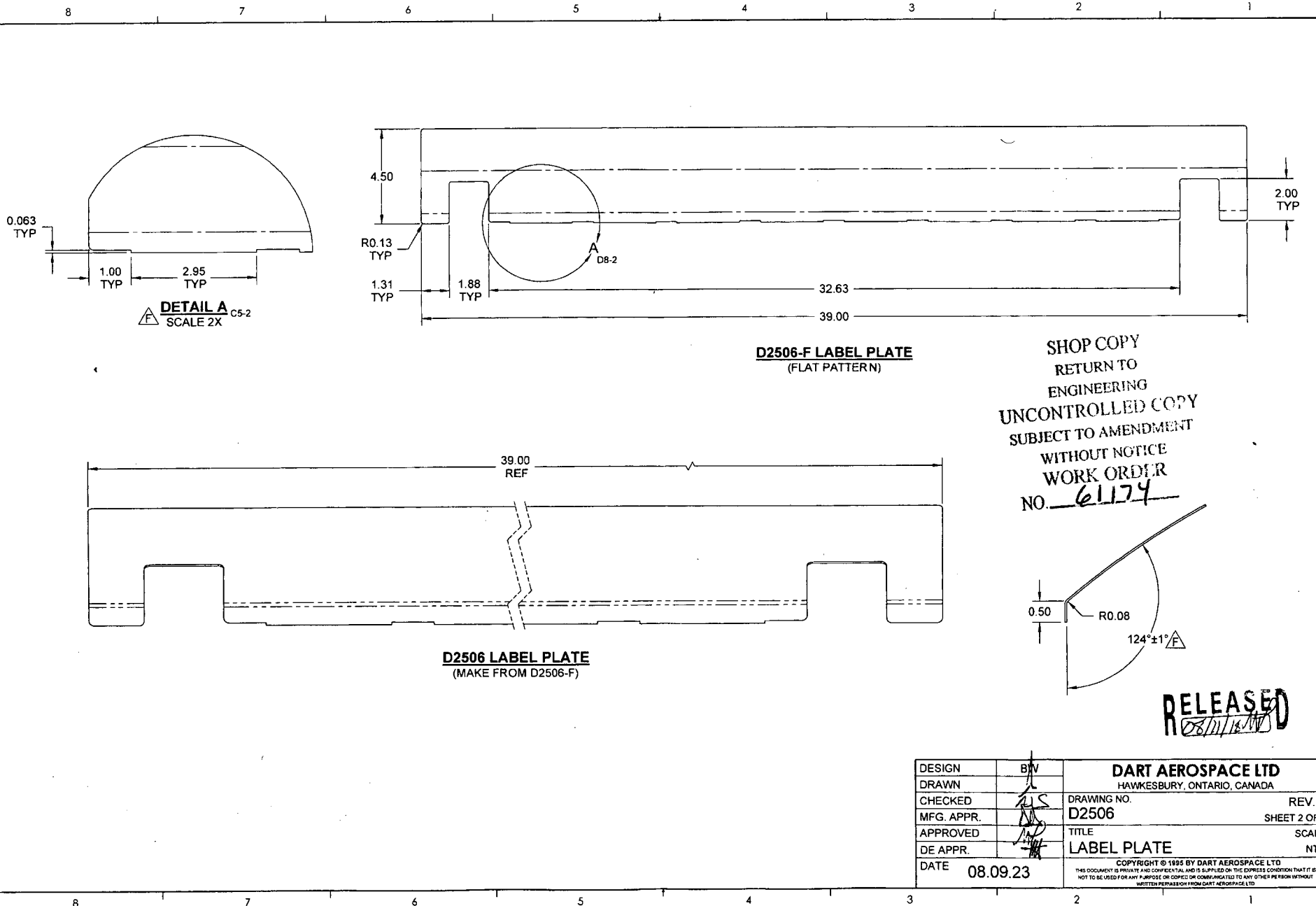
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WITHOUT NOTICE  
WORK ORDER  
NO. 61174  
CL 10/8/11

**RELEASE**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  $\triangle$   
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" x 1" WAS 127" (ZN A4-2); REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>JS</u>		
CHECKED	<u>JS</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>JS</u>	<b>D2506</b>	SHEET 1 OF 2
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	<b>LABEL PLATE</b>	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



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 WORK ORDER  
 NO. 61174

RELEASED  
 08/11/14

DESIGN	BYV	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO. <b>D2506</b>	REV. F
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